



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*81600\***

Page 2

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*8\***

**Cust Item ID:**

**\*8\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0.00

\*130\*

NC BRAKE

0.00

Brake NC

## Memo

Form using DT8179 Die and DT8157 as per Dwg D3315Rev: **B**

0.00

**\*140\***

QC6- Inspect dimensions to drawing

0.00

QC

## Memo

## Quality Control

0.00

**\*150\***

## Large Fab

0.00

### Large Fab

## Memo

Weld hard surface using D3315-3T3 as per QSI 004 and Dwg D3315 Rev:

Qty	Part Number	Description	Batch A/R
N/A	7560	Hardcoat Rod	M122359

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**NOTE:** Date & initial all entries

# Work Order ID 81600

March-16-12 8:35:32 AM

\*81600\*

Page 3

Item ID: D3315-3 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Wearplate  
 Start Date: 15/03/2012 Start Qty: 8.00 \*8\* Cust Item ID:  
 Required Date: 29/03/2012 Req'd Qty: 8.00 \*8\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00				(9x)		12-08-01	DAS 24 2-89
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				(89)			DAS 16 2-89 17/06/02
180 *180* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  Memo START TIME: 9h50 320°F FINISH TIME: 10h20	0.00  0.00				9	8	(20) 12/08/01	M 121279 ✓

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**NOTE:** Date & initial all entries

**\*81600\***

Page 4

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 15/03/2012    **Start Qty:** 8.00

**\*8\***

**Cust Item ID:**

**Required Date: 29/03/2012      Req'd Qty: 8.00**

**\*8\***

**Customer:**

**Reference:**

Approvals:      Process Plan: \_\_\_\_\_      Date: \_\_\_\_\_      Tooling: \_\_\_\_\_      Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

## Operation Description

## Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

QC3- Inspect Part Finish

0.00

\*190\*

QC

## Memo

0.00

## Quality Control

200

0.00

\*200\*

## Packaging

0.00

### Packaging

## Memo

### Packaging

Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3315-3, B/N: BXXXXX For Product Eligibility see PDA04-17 and Stock Location:

210

QC21- Final Inspection - Work Order Release

0.00

**\*210\***

QC

## Memo

0.00

## Quality Control

9<sup>th</sup> x d M nlog/oz

9x 8p  
128-7

12/8/8 JH

MCJ 12/08/07

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**NOTE:** Date & initial all entries



# Picklist Print

March-16-12 8:35:39 AM

Page 1

Work Order ID: 81600

\*81600\*

Parent Item: D3315-3

\*D3315-3\*

Parent Item Name: Wearplate

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 8.00

Required Qty: 8.00

## Comments:

IPP: A05.05.12New issueKJ/JLM  
IPP Rev:B As per Rev B 06-03-24 JLM  
IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA		Purchased	No			100	sf	69.0000	2.296	19.33474			

\*M1010S16GA\*

1010/1025 sheet 16GA

\*\*

Jan 12-6-25

Location	Loc Qty	Loc Code
MAT019	69	
116791	21.4	
117500	17.6	
118965	30	

121195

121195

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	81600
<b>Description:</b> Wearplate		<b>Part Number:</b>	D3315-3
<b>Inspection Dwg:</b> D3315 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                         
 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
62.75	+/-0.030	62.75"	-		MT	M301
58.094	+/-0.010	58.094"	✓		MT	"
51.368	+/-0.010	51.368"	✓		MT	"
44.531	+/-0.010	44.531"	✓		MT	"
37.719	+/-0.010	37.719"	-		MT	"
30.375	+/-0.010	30.375"	-		MT	"
24.188	+/-0.010	24.188"	-		MT	"
18.875	+/-0.010	18.875"	-		MT	"
17.375	+/-0.010	17.375"	-		MT	"
10.594	+/-0.010	10.594"	-		✓	Prod W302
5.375	+/-0.010	5.374"	-		✓	m301
0.875	+/-0.010	0.873"	-		✓	"
1.62	+/-0.030	1.617"	-		✓	"
5.214	+/-0.010	5.209"	-		✓	"
4.402	+/-0.010	4.403"	-		✓	"
3.550	+/-0.010	3.560"	-		✓	"
Ø0.300	+0.006/-0.001	0.302"	✓		✓	"
Ø0.266 x 0.450	+/-0.010	0.267" x 0.454"	-		✓	"

<b>Measured by:</b>	Jm
<b>Date:</b>	12-6-24

<b>Audited by:</b>	mt/mt
<b>Date:</b>	12 06 25

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

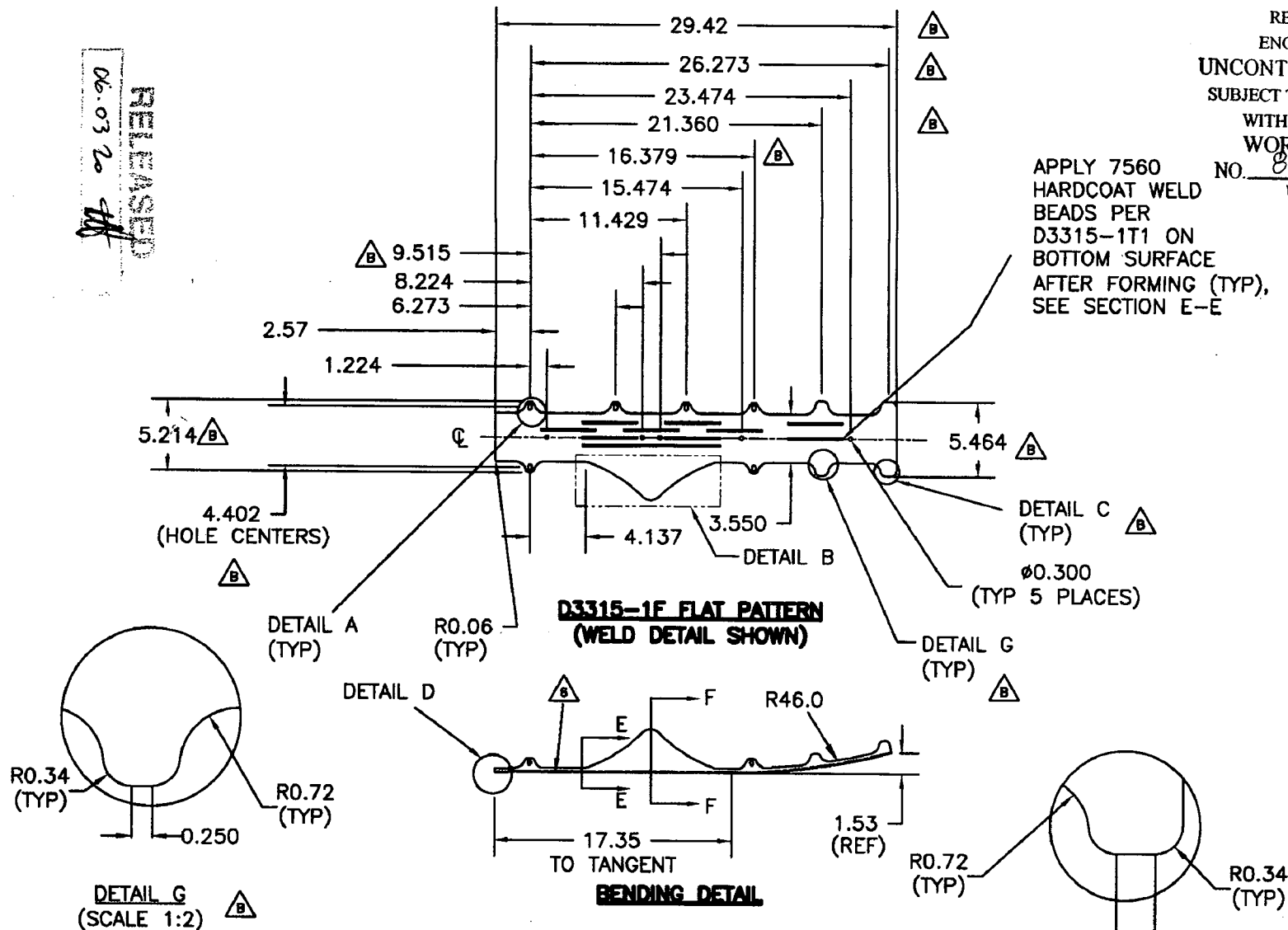
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

RELEASED  
06.03.20



APPLY 7560  
HARDCOAT WELD  
BEADS PER  
D3315-1T1 ON  
BOTTOM SURFACE  
AFTER FORMING (TYP),  
SEE SECTION E-E

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 81600 M/LJ  
12/03/16

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD
PH	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3315
DATE	TITLE	REV. B
06.01.31	WEARPLATE	SHEET 1 OF 4
A	NEW ISSUE	SCALE
04.09.10		1:12
B	UPDATE DIMENSIONS	
06.01.31		

**D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
  - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
  - 3) WELD PER DART QSI 004
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

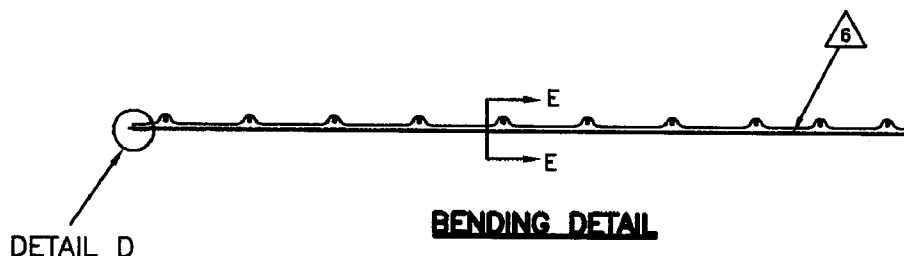
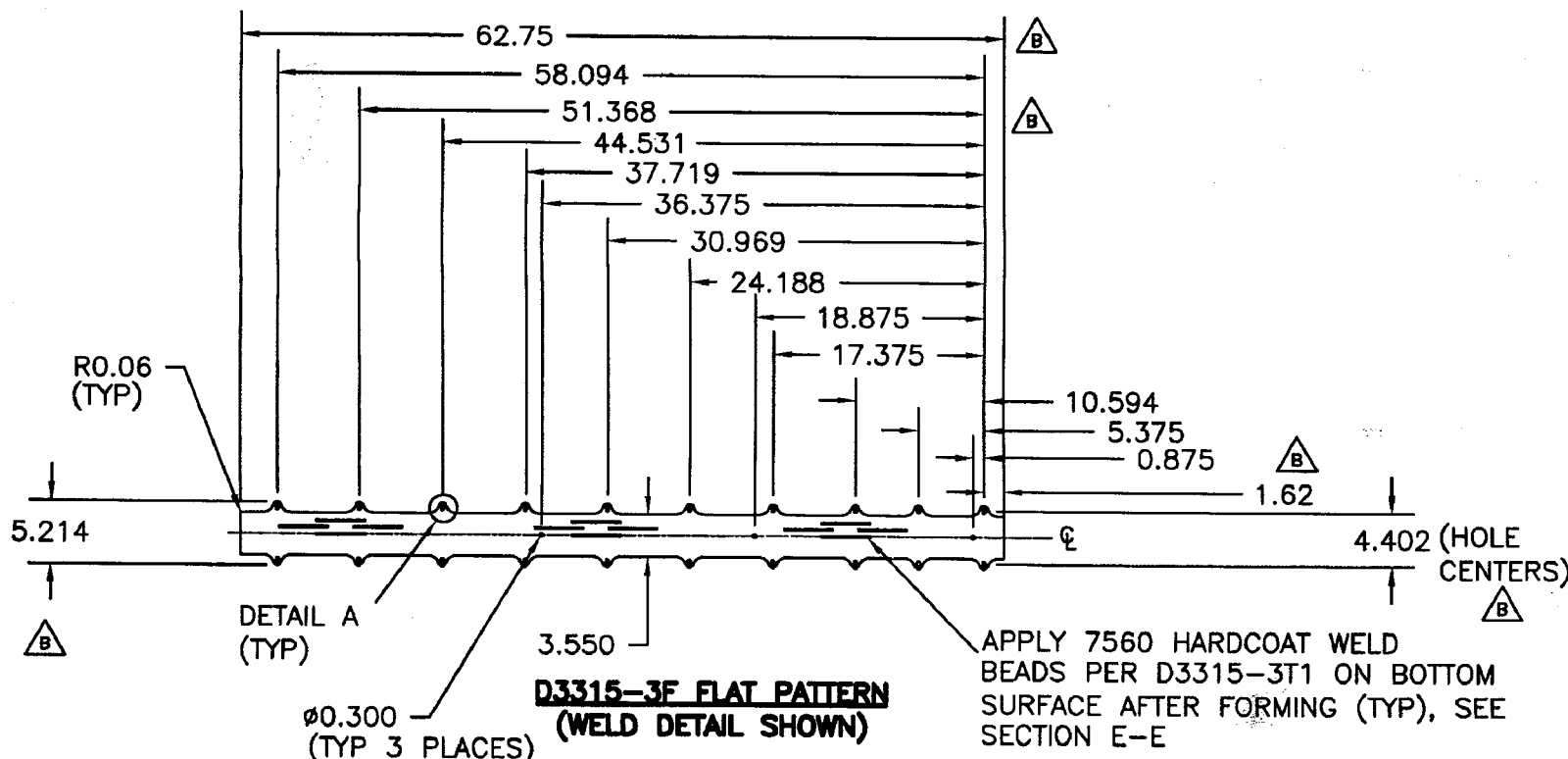
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3315	SHEET 2 OF 4
DATE	06.01.31	TITLE	WEARPLATE	SCALE	1:16



**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED  
06.03.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

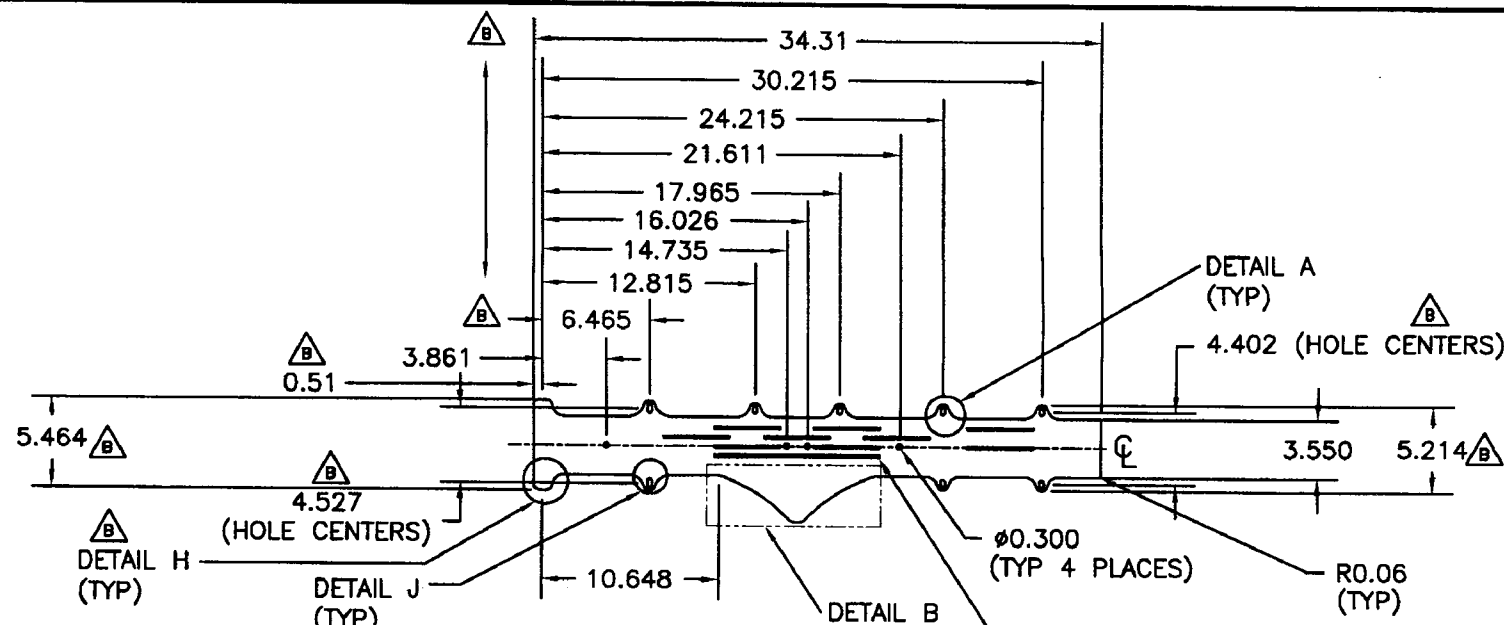
**NOTE:** Date & initial all entries



8/1600

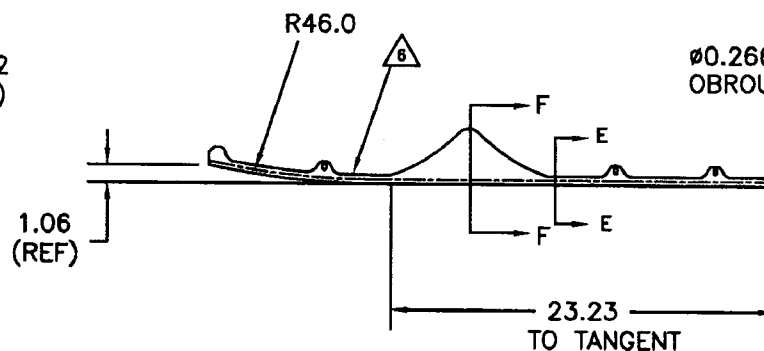
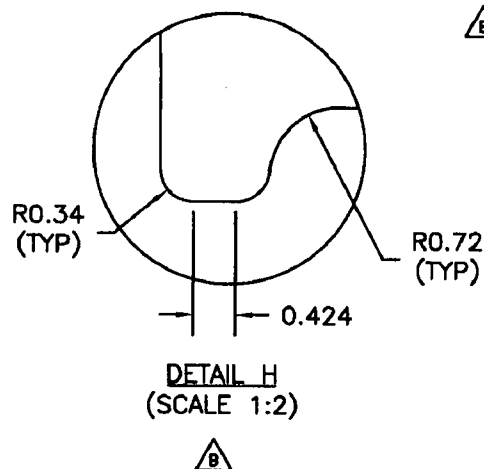
**DART**

DESIGN	814	DRAWN BY	814	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	DRAWING NO.	D3315	REV. B
		TITLE	WEARPLATE	SHEET 3 OF 4
		SCALE	1:12	

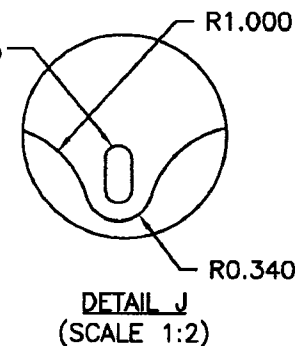


**D3315-5F FLAT PATTERN  
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD  
BEADS PER D3315-5T1 ON BOTTOM SURFACE  
AFTER FORMING (TYP), SEE SECTION E-E



**BENDING DETAIL**



**D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
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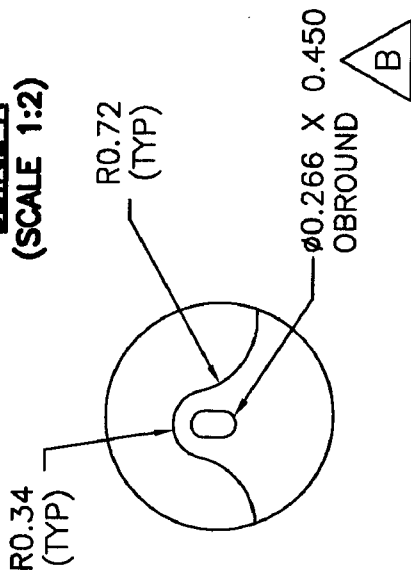
**NOTE:** Date & initial all entries

01600

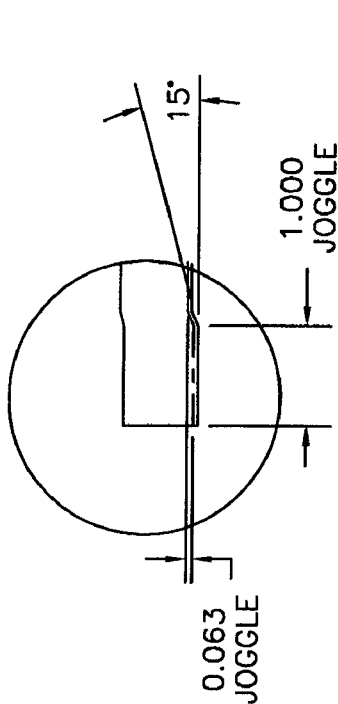


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31		TITLE WEARPLATE	SCALE NTS

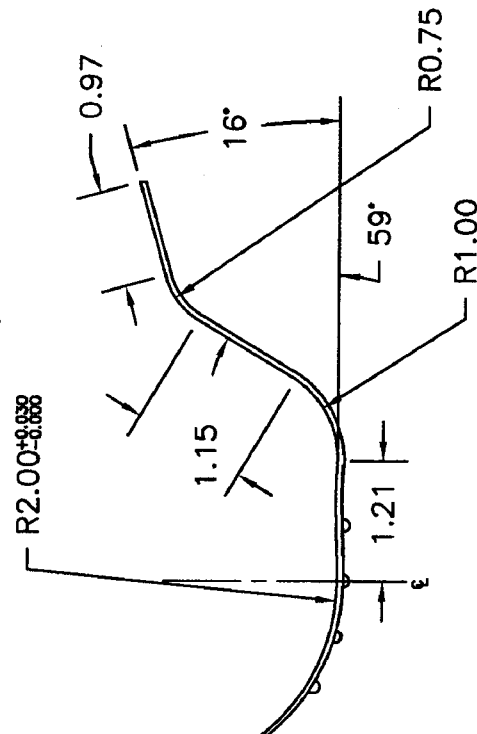
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(SCALE 1:2)



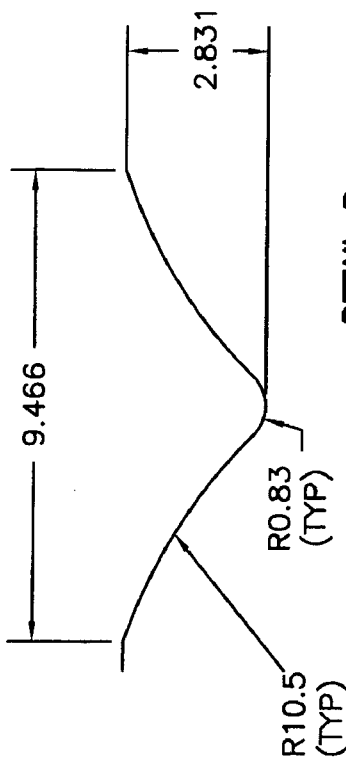
RELEASED  
06.03.20



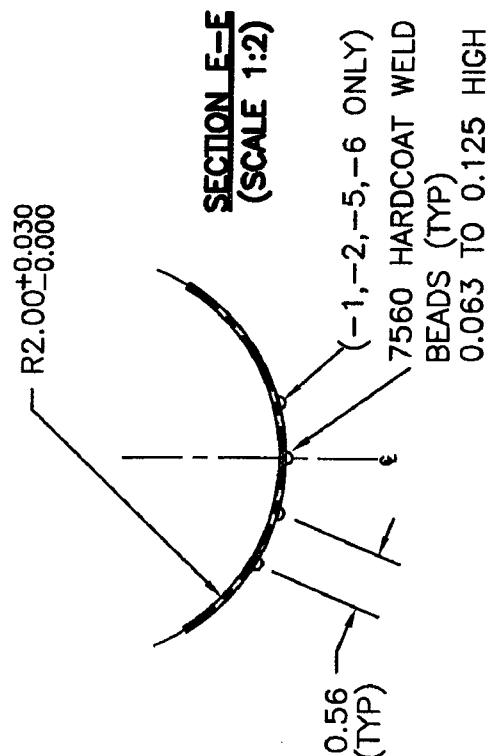
**DETAIL D**  
(SCALE 1:2)



**SECTION F-F**  
(SCALE 1:2)



**DETAIL B**  
(SCALE 1:4)



**SECTION E-E**  
(SCALE 1:2)

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